

Work Order ID 51555

August 25, 2009 2:09:02 PM

Page 1

Item ID: D3955-041

Accept

Revision ID: A

Item Name: Doubler Assembly

Start Date: 8/26/09

Start Qty: 3.00

Required Date: 8/28/09

Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-8-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3955

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3955-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

HB

9-8-26

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

HB 9-8-26

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/6/26	130	Found Qty of Part with a dimple made from CSinking next to a CSink R.C. employee missed judged the location of the hole. L.A.S.						9/6/26
								9/6/26

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 51555

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Page 3

Item ID: D3955-041
Revision ID: A
Item Name: Doubler Assembly

Accept

Setup Start

Stop

Start Date: 8/26/09 Start Qty: 3.00
Required Date: 8/28/09 Req'd Qty: 3.00




Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	09/08/26			A	8		
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BR09-08-26			(4)			
170  Packaging Packaging	Pick Kit Memo	0.00 0.00	2						Pick Kit (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 2:09:01 PM

Work Order ID: 51555

Parent Item: D3955-041RevA

Parent Item Name: Doubler Assembly



Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 3.00 *7*

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	120.1891	1.1220			
												
6061-T6 .063 Sheet												

FB 9-8-06

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

120.1891211

109463

-0.0223

110551

120.211421

MS21086L3 Purchased

No

180

Each

43.0000

3.0000 *4*

110551



Nut Plate

Peg/spe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

43

112219

43

MS20427M3-3 Purchased

No

180

Each

400.0000

6.0000 *8*

112219



Rivet

Peg/spe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

400

110022

115

111819

285

111819

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51555
Description: Doubler		Part Number: D3955-1
Inspection Dwg: D3955	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	*			
Ø0.201	+0.005/-0.001	0.203	*			
0.750	+/-0.010	0.752	*			
1.000	+/-0.010	1.002	*			
1.250	+/-0.010	1.251	*			
1.375	+/-0.010	1.379	*			
2.38	+/-0.030	2.381	*			
0.613	+/-0.010	0.612	*			
1.313	+/-0.010	1.313	*			
2.063	+/-0.010	2.069	*			
2.563	+/-0.010	2.566	*			
3.063	+/-0.010	3.070	✓			
4.813	+/-0.010	4.816	✓			
6.313	+/-0.010	6.315	*			
7.313	+/-0.010	7.314	*			
7.813	+/-0.010	7.812	*			
8.199	+/-0.010	8.201	*			
8.449	+/-0.010	8.450	*			
9.188	+/-0.010	9.189	*			
9.438	+/-0.010	9.438	*			
10.413	+/-0.010	10.412	*			
10.75	+/-0.030	10.736	*			
0.063	+/-0.010	0.064	*			

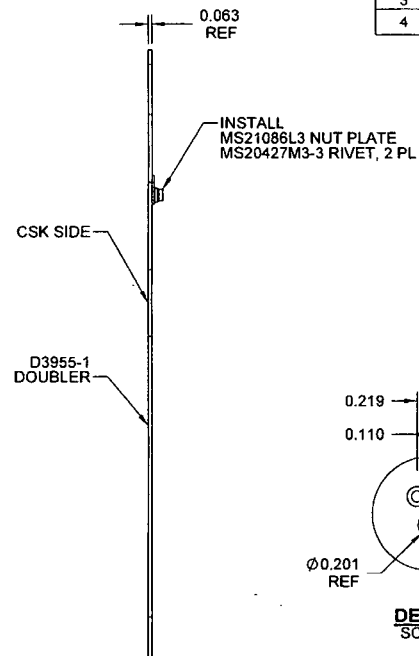
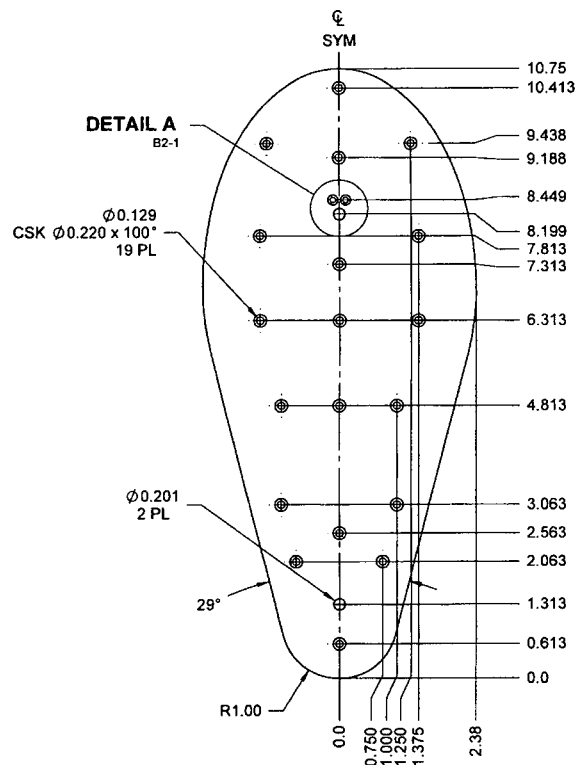
Measured by: HB
Date: 9-8-26

Audited by: S
Date: 02/06/26

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue P/O D3955-041	KJ	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



DETAIL A D7-1
SCALE 2X

D3955-041 DOUBLER ASSEMBLY

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

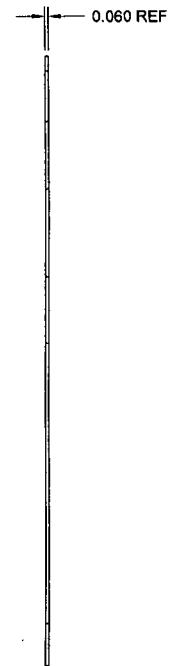
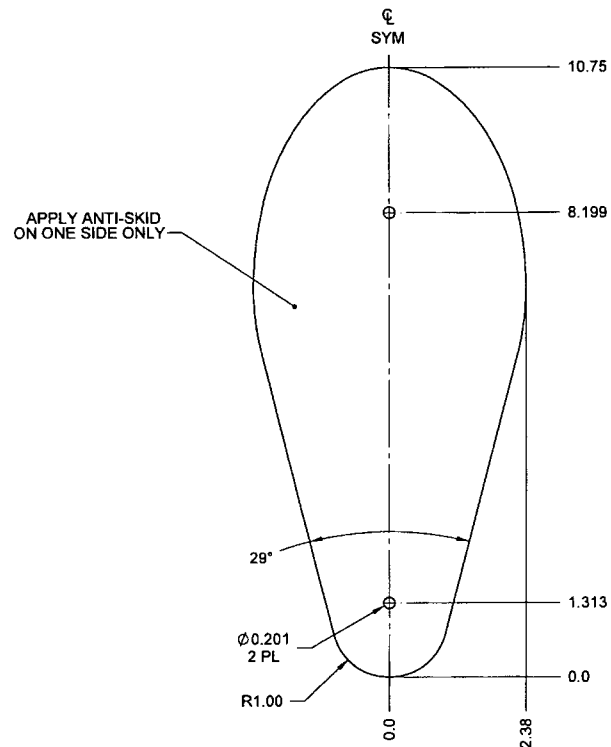
A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.21		

RELEASED
09/07/21

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3955** REV. A
SHEET 1 OF 5
TITLE **SKIDTUBE TUNING KIT** SCALE NTS

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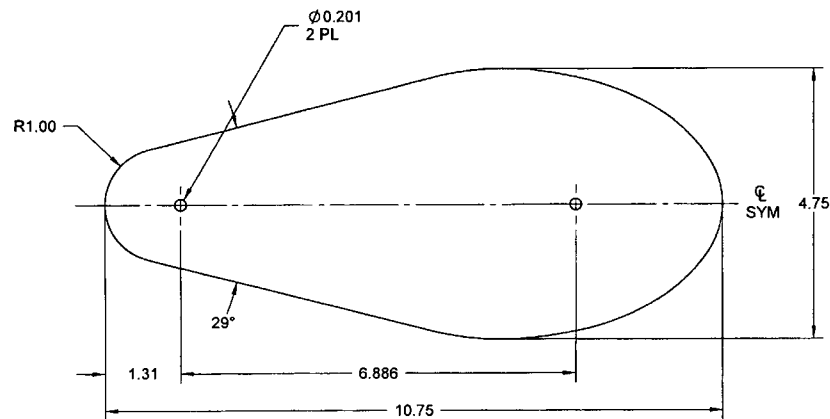
D3955-3 COVER PLATE

51955
RELEASED

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3955	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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D3955-X PLATE

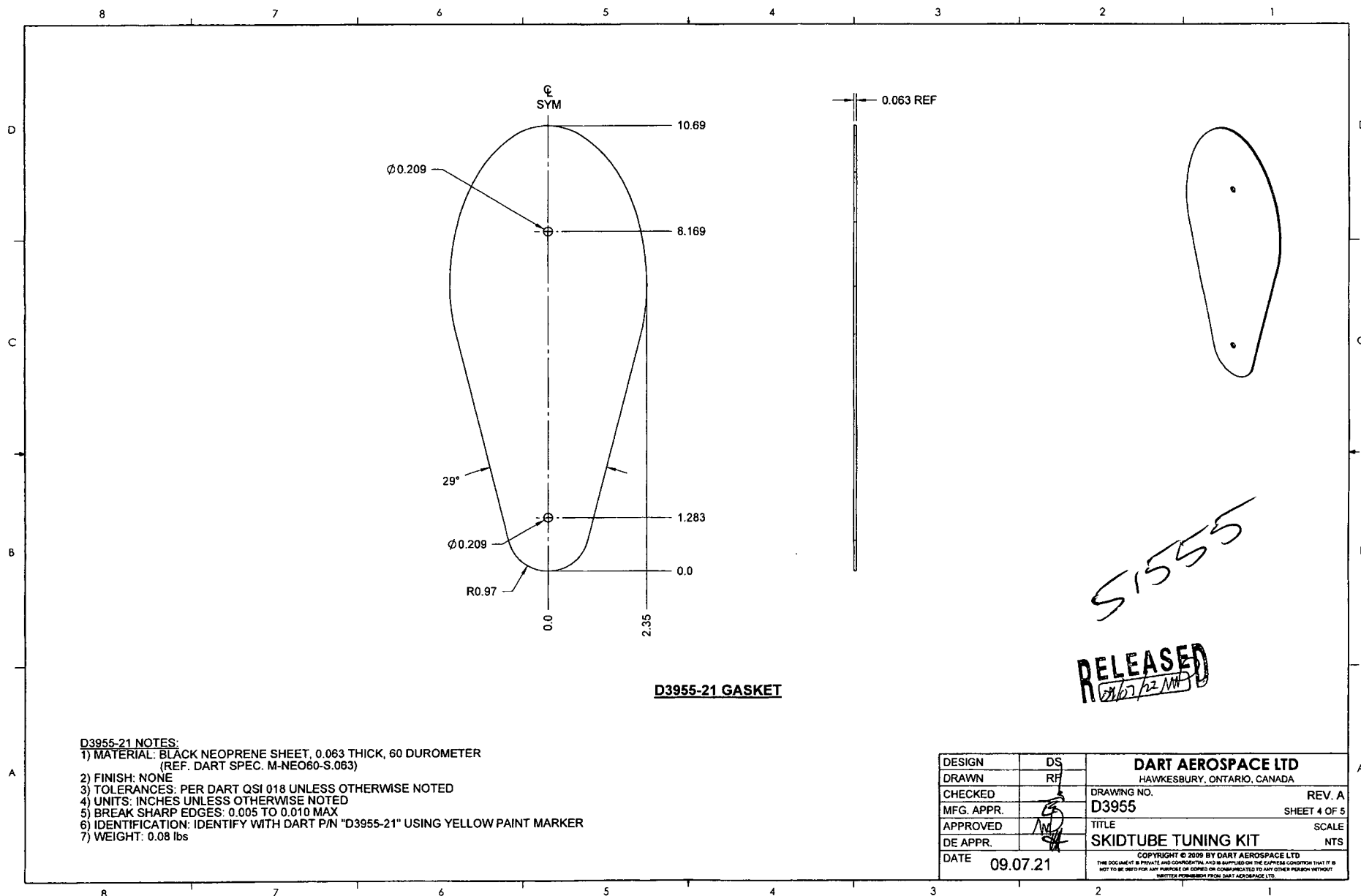
General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304ST'GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

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09/07/21

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DATE	09.07.21		

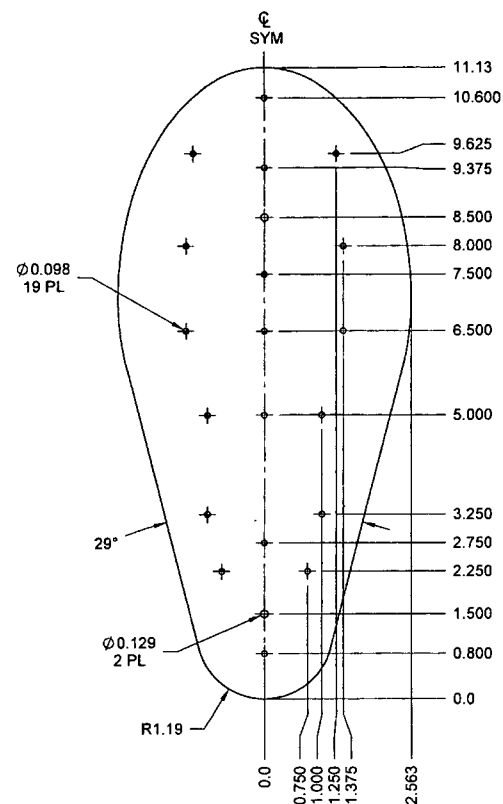


D3955-21 GASKET

D3955-21 NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

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D3955-23 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

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